

Work Order ID 60844

Monday, July 26, 2010 10:40:28 AM



Page 1

Item ID: D2282-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Assembly

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

10-7-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly

A/RER316L SS

Filling Rod

Dwg Rev: *E*

M114509 / M107051

11.04.26 20

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

20X
7m-1 11/04/27

120 0.00



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

11.05.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page:2

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Stop



Item Name: Saddle Assembly

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Memo

0.00

Small Fab

1 -Tumble

B11-5-4

20

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/05/04

counts
x20

160

Identify as per dwg & Stock Location: 261

0.00



Packaging

Memo

0.00

Packaging

JB

11/05/04

W/O:		WORK ORDER CHANGES					
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Page 3

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Item ID: D2282-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Assembly

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10 [Signature]

ME
11-05-05

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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 10:40:32 AM

Page 1

Work Order ID: 60844

Parent Item: D2282-043

Parent Item Name: Saddle Assembly

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2281		Manufactured	No			100	Each	19.0000	1	20			
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Jack Saddle

B67539

Location

Loc Qty

Loc Code

ST261

19

59804

19

D2282-7		Manufactured	No			100	Each	272.0000	2	40			
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Tube

Location

Loc Qty

Loc Code

WA

272

59803

3

60284

120

60488

149

B64507



20

11.04.26



40

11.04.26

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NOTE: Date & initial all entries

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WITHOUT
WORK

DART

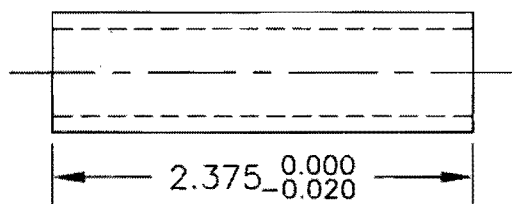
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60849
210-726

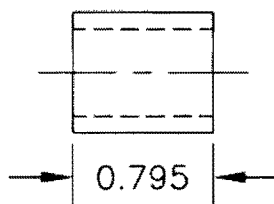
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BS/09/16

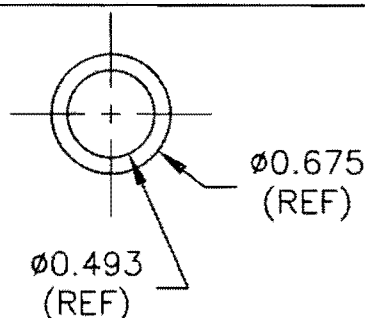
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3

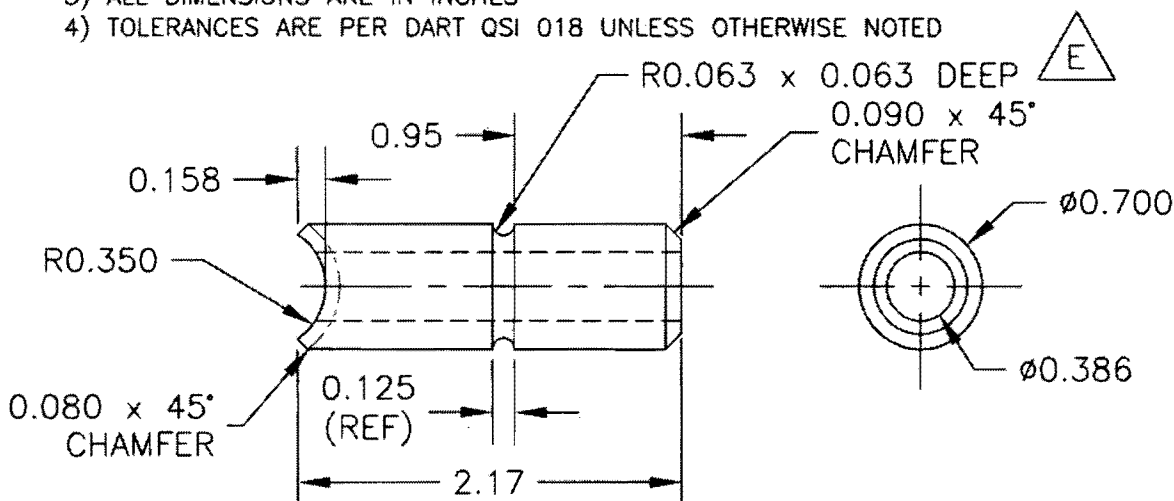


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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Dart Aerospace Ltd

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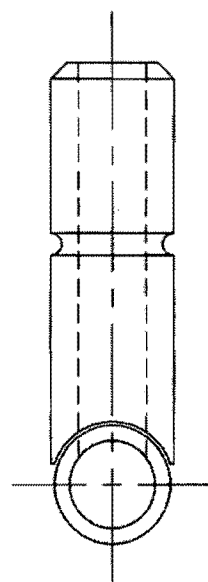
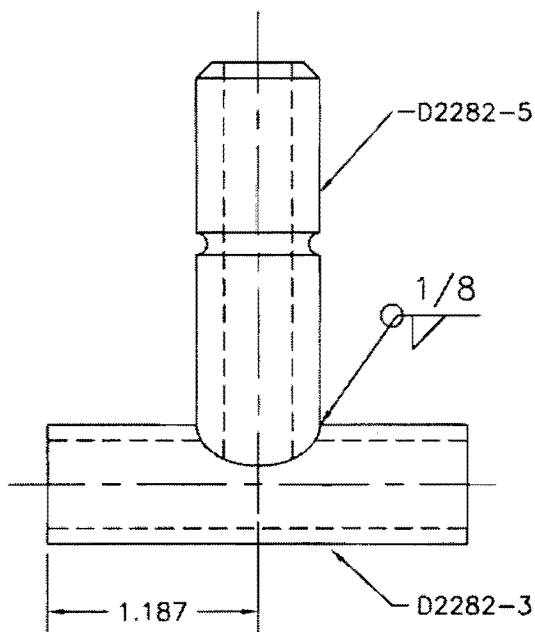
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



RELEASED

05/09/16

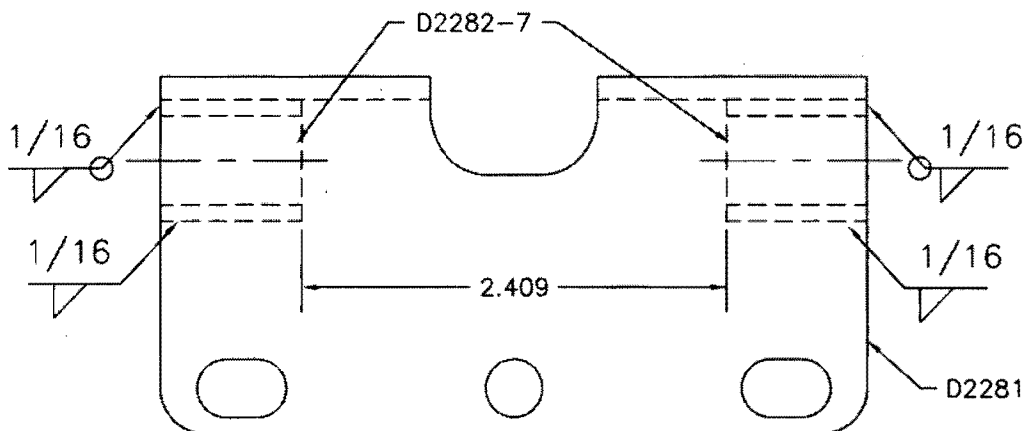
w/o 60844

D2282-041
(REF)

D2282-043
(REF)

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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